

Work Order ID 162668

Wednesday, June 07, 2017 1:43:15 PM

162668

Page 1

Item ID: SK145-0114-01

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Trailing Bar Assembly, Rotor Blade, Folding (661K1891-105A)

Start Date: 6/22/2017 Start Qty: 5.00***5***

Cust Item ID:

Required Date: 6/28/2017 Req'd Qty: 5.00***5***

Customer:

Reference:

7/21 PA. 2017/06/07

Approvals:

Process Plan:

PK

Date:

2017-06-07

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

SK145-0114

Rev A

110

0.00

110

Small Fab

Memo

0.00

Small Fab

1- INSTALL -02 HOOK TO -20 TUBE AS PER DWG.

2- INSTALL -23 COLLAR

3- INSTALL -21 TAPE (6047T33) TO -20 TUBE (40" LONG AS PER DWG)
6047T33 BATCH: 137797

4- INSTALL -40 END CAP AS PER DWG

~~AUG 01 2017~~

AUG 03 2017

DAS
19
9-00

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

⑤ 17-08-03 PD

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Page 2

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130									
Packaging	Memo	0.00				5	DAS 28	AUG 04 2017	
Packaging							9-89		
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									



AUG 04 2017

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162668

SK145-0114-01

Required Date: 6/28/2017

Required Qty: 5.00

Comments: IPP REV:A 17.05.31 NEW ISSUE DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
84735K117		Purchased	No			110	Each	0.0000	1	5		JUL 26 2017	DAS
84735K117													
Cap									**	132746			6
92198A111		Purchased	No			110	Each	0.0000	1	5			9-8
92198A111													
Bolt									**	137797		JUL 26 2017	DAS
MS21042L4		Purchased	No			110	Each	2,979.000	1	5			6
MS21042L4													
Nut									**				9-89
												JUL 26 2017	DAS
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						FP001	10						
						m133363	10						
						GA	51						
						m135058	51						
						OVER007	2400						
						m137402	400						
						m137544	1000						
						m137680	1000						
						ST303	518						
						m137371	518						
MS35338-44		Purchased	No			110	Each	0.0000	1	5			
MS35338-44													
LOCK WASHER									**	138085			

JUL 26 2017

Picklist Print

Wednesday, June 07, 2017 1:43:15 PM

Page 2

Work Order ID: 162668

162668

Parent Item: SK145-0114-01

SK145-0114-01

Parent Item Name: Trailing Bar Assembly, Rotor Blade, Folding (661K1891-105A)

Start Date: 6/22/2017

Required Date: 6/28/2017

Start Qty: 5.00

Required Qty: 5.00

NAS1149F0463P

Purchased

No

110

Each

325.0000

1

5

NAS1149F0463P

**

Washer

Location

Loc Qty

Loc Code

ST262

325

m127832

325

SK145-0114-02

Manufactured

No

110

Each

0.0000

1

5

SK145-0114-02

Hook Weldment

B 162710 **

DAS
30
9-89

SK145-0114-20

Manufactured

No

110

Each

0.0000

1

5

SK145-0114-20

Tube

B 162740 **

DAS
30
9-89

AUG 02 2017

SK145-0114-22

Manufactured

No

110

Each

0.0000

1

5

SK145-0114-22

Bushing

**

162741

JUL 26 2017

DAS
6
9-89

SK145-0114-23

Manufactured

No

110

Each

0.0000

1

5

SK145-0114-23

Collar

**

162743

JUL 26 2017

DAS
6
9-89

SK145-0114-26

Manufactured

No

110

Each

0.0000

1

5

SK145-0114-26

Hook Pad

**

162748

B 162748

JUL 26 2017

DAS
6
9-89

JUL 31 2017

D

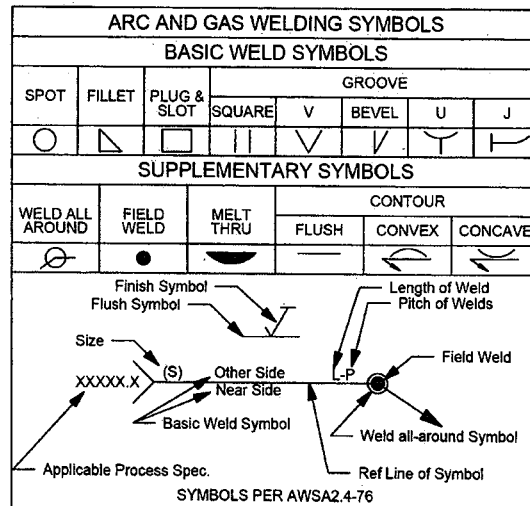
C

B

A

NOTES:

1. INTERPRET DRAWING IAW ASME Y14.100
2. UNLESS OTHERWISE SPECIFIED, HOLES INDICATED WITH 3 PLACE PRECISION (ϕ .XXX) TOLERANCED IN ACCORDANCE WITH ASME B4.1-1967 CLASS LC 11 (HOLE H13).
3. CALCULATED FASTENER LENGTHS SHOWN.
ACTUAL FASTENER LENGTHS TO BE DETERMINED AT INSTALLATION.
4. FUSION WELDING IN ACCORDANCE WITH AWS D1731 CLASS A UNLESS OTHERWISE SPECIFIED.
5. FUSION WELDING INSPECTION TO BE ACCOMPLISHED VISUALLY.
6. POWDER COAT NON ID SURFACES, EXCEPT SURFACE OF ITEM 02 TO WHICH ITEM 26 WILL BE BONDED, USING IFC COATINGS CUSTOM YELLOW P747 PT. OVERSPRAY ACCEPTABLE.
7. IDENTIFY MANUFACTURED PARTS PER MIL-STD-130 AS FOLLOWS: [CAGED] [PN] [REV].
EXAMPLE: 81205 1234567890-501 A
8. SCUFF THE BOTTOM OF ITEM 26 AND THE TOP OF ITEM 02 PRIOR TO ADHERING THEM TOGETHER
9. BOND ITEM 26 TO ITEM 02 USING ONE OF THE FOLLOWING:
 - ITEM 45
 - CA40 (3M)
 - ITEM 46 WITH ITEM 47IF CA40 OR ITEM 46 WITH ITEM 47 ARE USED, PRIME SURFACE WITH ITEM 48 IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS



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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED
SUBJECT TO AMENDM
WITHOUT NOTICE
WORK ORDER
NO. 162688

20170607

AR	48	PR200	METAL PRIMER	REMA		
AR	47	SC2000	CEMENT	REMA		
AR	46	UTR20	HARDENER	REMA		
AR	45	495	ADHESIVE	LOCTITE		
1	44	92198A111	BOLT	MIL SPEC		
1	43	NAS1149F0463P	WASHER	MIL SPEC		
1	42	MS35338-44	WASHER	MIL SPEC		
1	41	MS21042L4	BOLT	MIL SPEC		
1	40	84735K117	CAP	76A DIAPHRAGM, BLACK		
1	26		-26 HOOK PAD	EPDM		
1	25		-25 FITTING	AT&T 301 ANL AMS 5801		
1	24		-24 HOOK	HOT ROLLED STEEL SHEET	.125	
1	23		-23 COLLAR	84735K117 CAGEC 38426		
1	22		-22 BUSHING	ALB1 301 ANL AMS 5801	ϕ .438	
1	21		-21 GRIP	BLACK VIVID VINYL	1.5	
1	20		-20 TUBE	2024-T3 AL ALY AMS-02-A-250/4	ϕ 1.000 X .080 WT	
05						
04						
03						
1	02		-02 HOOK WELDMENT			
01			-01 TRAILING BAR ASSY, ROTOR BLADE, FOLDING	661K1891-105A		
-05	-04	-03	-02	-01	ITEM NO.	
QTY	REQD	PART NUMBER	DESCRIPTION	MATL/SOURCE	STOCK SIZE	NOTES

LIST OF MATERIALS

UNLESS OTHERWISE SPECIFIED,
DIM ARE IN INCHES
TOL ON ANGLES $\pm$.5°
1 PLACE $\pm$.1
2 PLACE $\pm$.03
3 PLACE $\pm$.010
INTERPRET DIM AND TOL
PER ASME Y14.5-1994

DRAWING RELEASE ORDER
145-0981

NAME	DATE
ENGR MGR	3/23/16
PROJ ENGR	3/23/16
ENGR CK	
DRAFT CK	3/23/16
DRAWN BY	J. Lo Piccolo
NEXT ASSEMBLY	2/3/15



TITLE
TRAILING BAR ASSY, ROTOR BLADE,
FOLDING

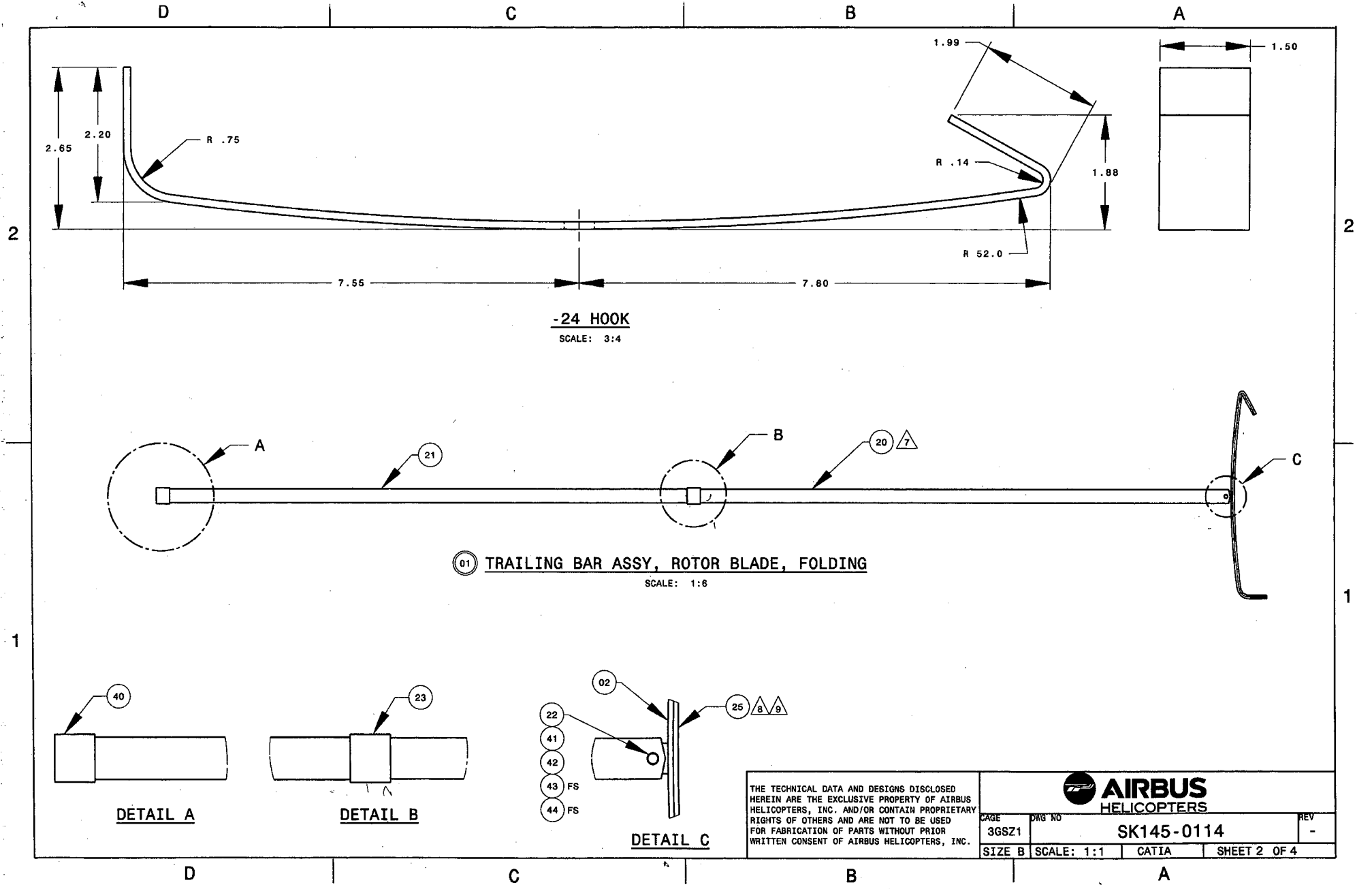
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3GSZ1	SK145-0114	-
SIZE B	SCALE: NONE	CATIA
SHEET	1 OF 4	

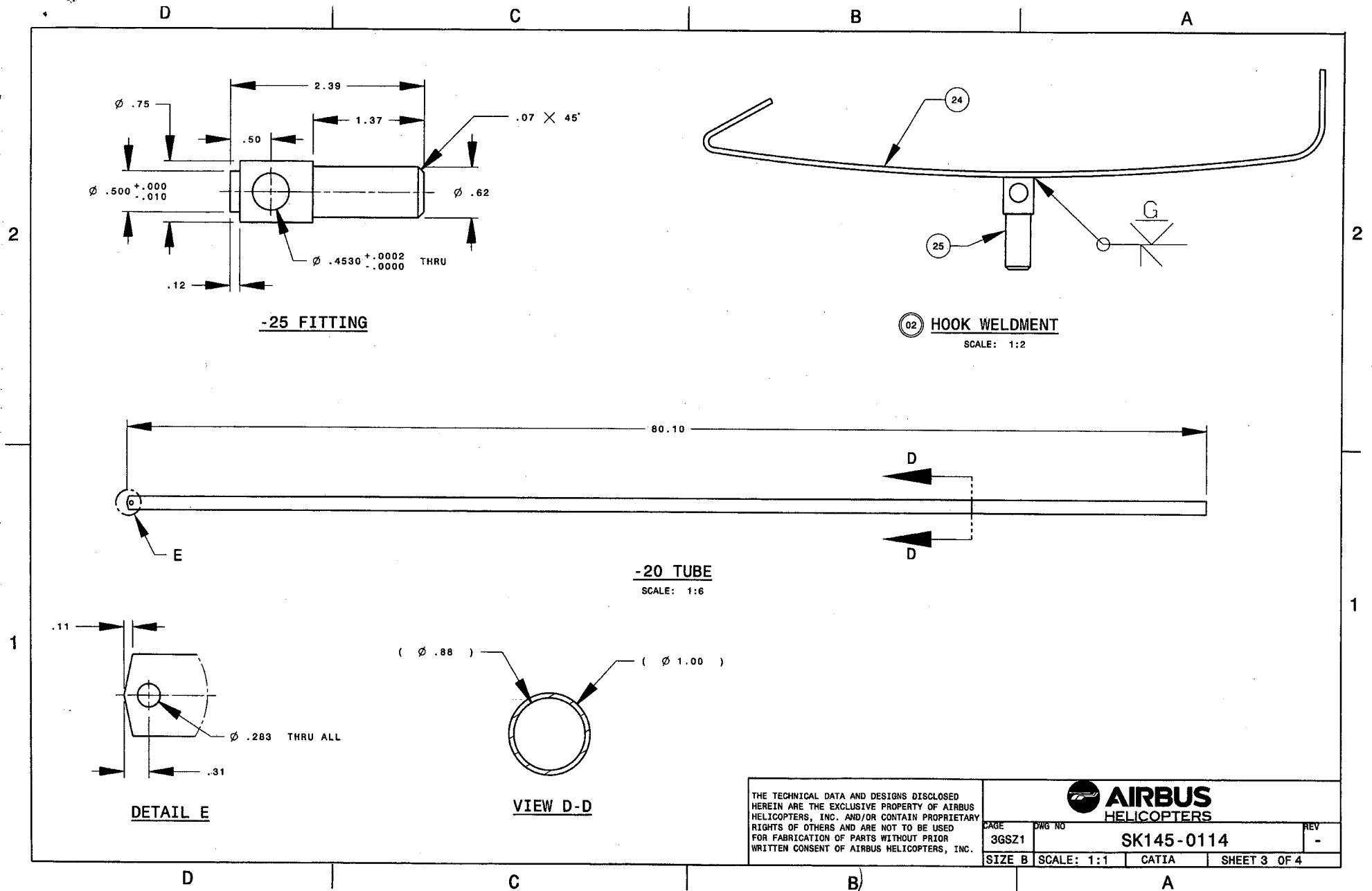
D

C

B

A



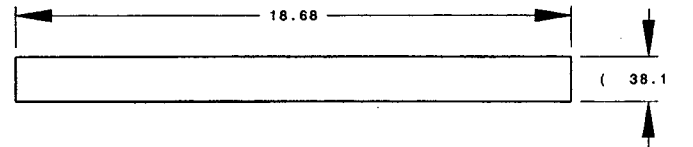
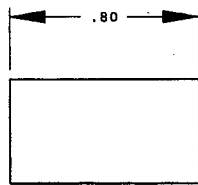


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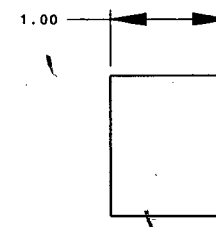
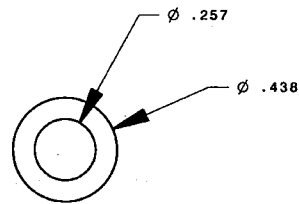
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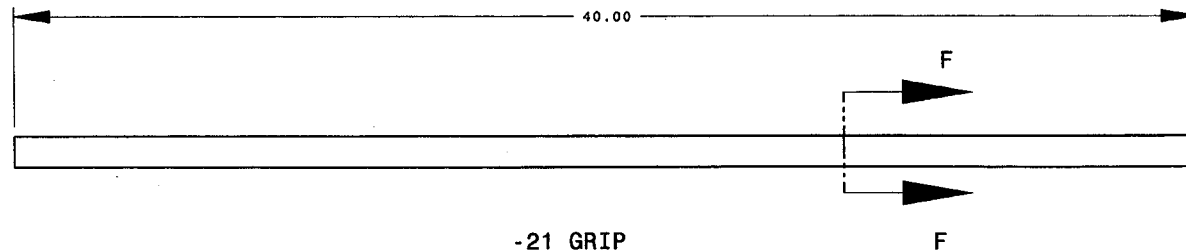
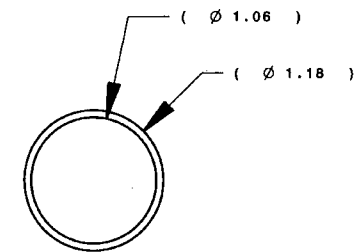
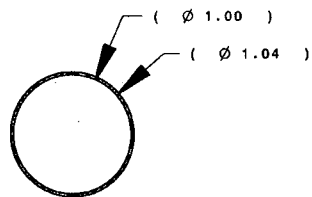
A

-26 HOOK PAD-22 BUSHING

SCALE: 2:1

-23 COLLAR

SCALE: 1:1

-21 GRIPVIEW F-F

SCALE: 1:1

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AIRBUS
HELICOPTERS

CAGE	DWG NO	REV
36SZ1	SK145-0114	-
SIZE B	SCALE: 1:4	CATIA
SHEET 4 OF 4		

D

C

B

A

22

1

D

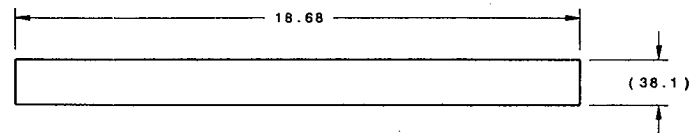
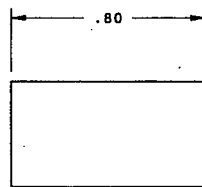
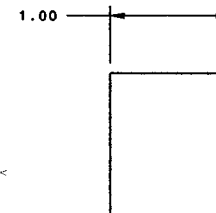
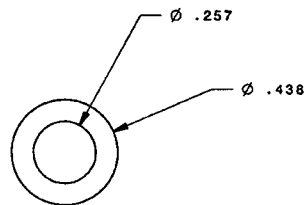
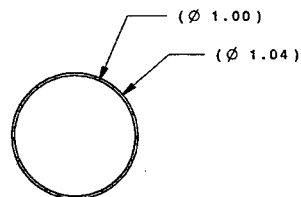
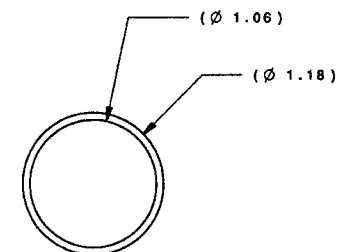
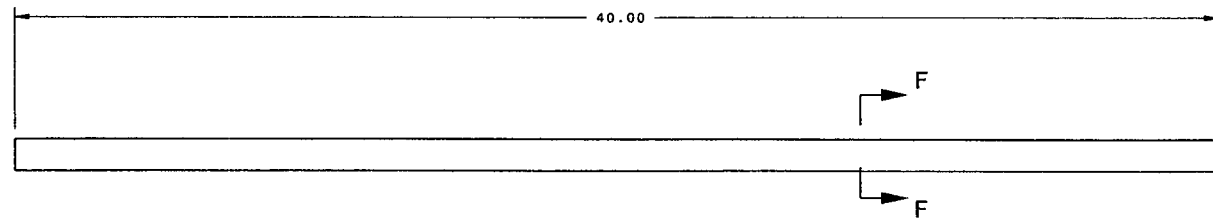
C

1.

8

AIRBUS

SIZE B	SCALE: NONE	CATIA	SHEET 1 OF 4
--------	-------------	-------	--------------

-26 HOOK PAD-22 BUSHING
SCALE: 2:1-23 COLLAR
SCALE: 1:1VIEW F-F
SCALE: 1:1-21 GRIP

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AIRBUSCAGE
3GSZ1

DWG NO

SK145-0114

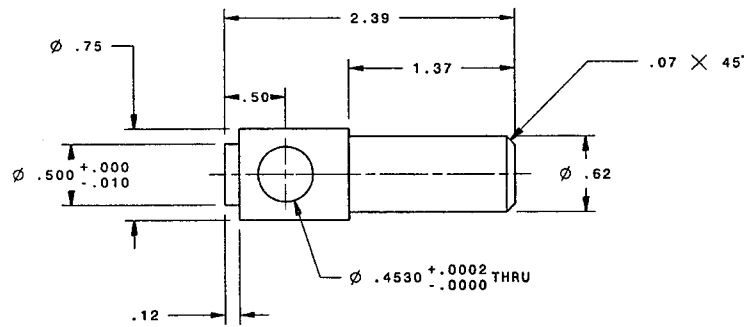
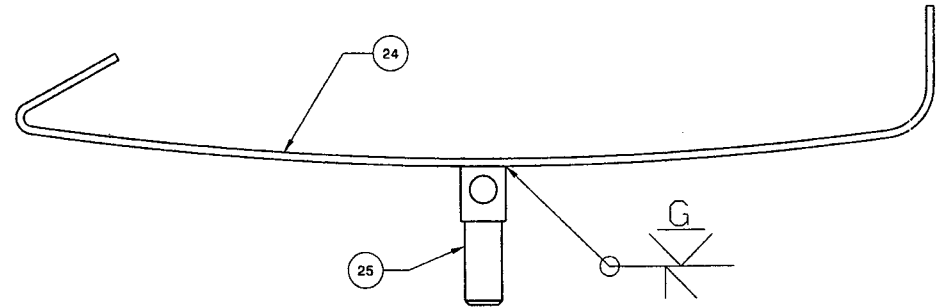
REV
A

SIZE B

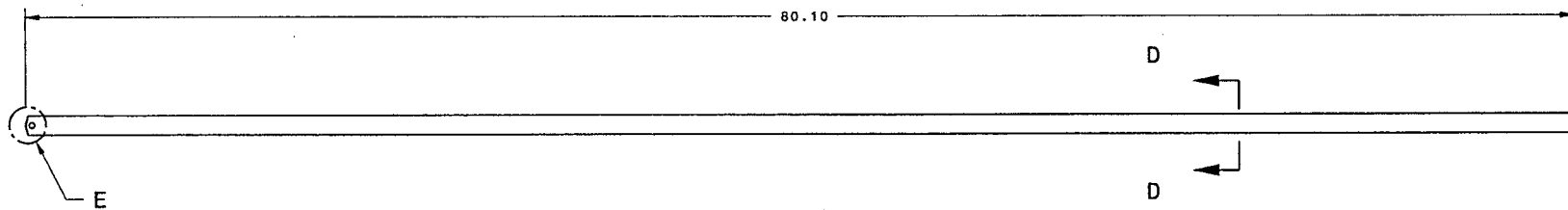
SCALE: 1:4

CATIA

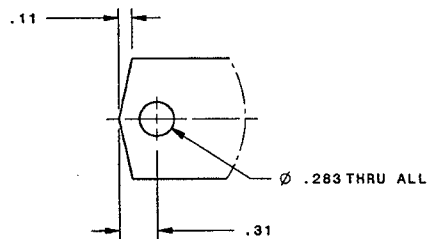
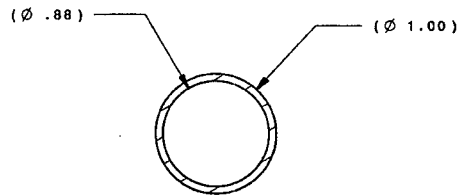
SHEET 4 OF 4

-25 FITTING02 HOOK WELDMENT

SCALE: 1:2

-20 TUBE

SCALE: 1:6

DETAIL EVIEW D-D

THE TECHNICAL DATA AND DESIGNS DISCLOSED
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AIRBUSCAGE
36SZ1

DWG NO

SK145-0114

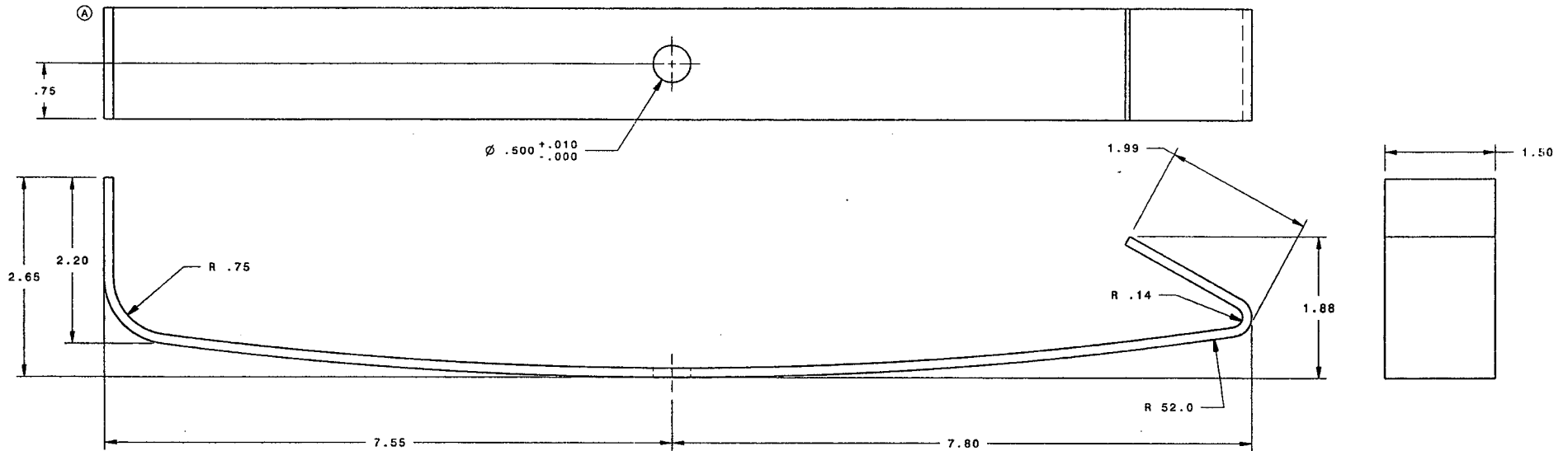
REV
A

SIZE B

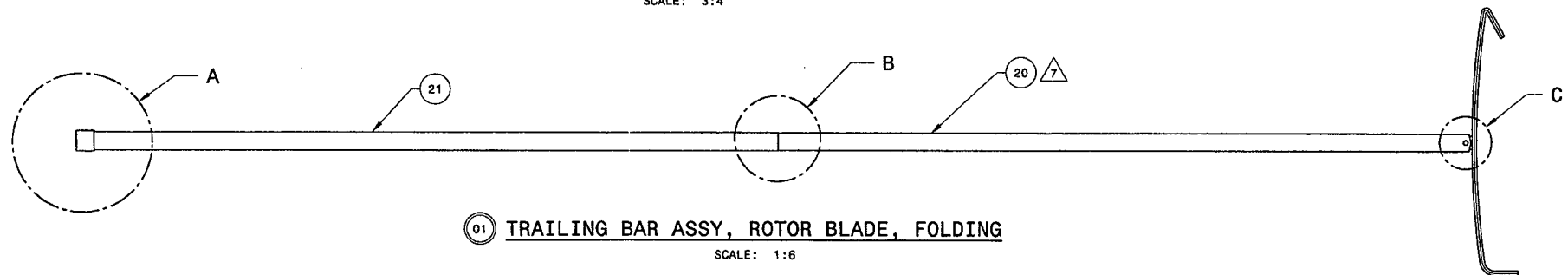
SCALE: 1:1

CATIA

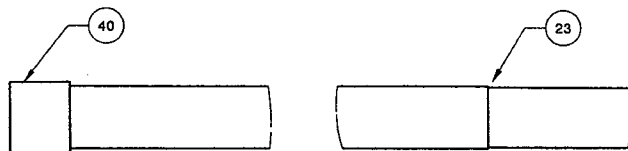
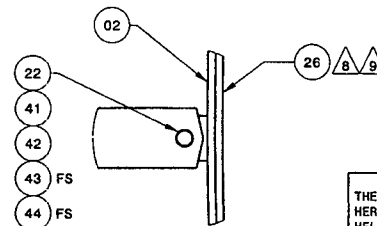
SHEET 3 OF 4

**-24 HOOK**

SCALE: 3:4

**01 TRAILING BAR ASSY, ROTOR BLADE, FOLDING**

SCALE: 1:6

**DETAIL A****DETAIL B****DETAIL C**

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AIRBUS

CAGE 3GSZ1	DWG NO SK145-0114	REV A
SIZE B	SCALE: 1:1	CATIA
SHEET 2 OF 4		